

# Work Order ID 76756

**\*76756\***

Page 1

November-21-11 10:28:59 AM

Item ID: D2654-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Web  
 Start Date: 21/11/2011 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 02/01/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.S Date: 11/11/21 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2654	F

100 Skidtubes 0.00  
**\*100\***  
 Skidtubes Memo 0.00  
 Skidtubes  
 1-Cut D2600-5 to length as per Dwg D2654  
 2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654  
 3-Using the uni-bit, open holes to finish size as per Dwg D2654  
 4-Deburr holes and ends

110 QC5- Inspect part completeness to step on W/O 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

120 Chemical Conversion Coat per QS1005 4.1 0.00  
**\*120\***  
 HandFinish Memo 0.00  
 Hand Finishing

11-12-22 (10)

(+10)

Pro →

(10)

11-12-22

W/O: 76756		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/12/12	# 110 + 120	Revs step # 110 + 120. w/ should be <del>200</del> check cost for QS					S 11/12/12	

Part No: D2654-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 76756****\*76756\***

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November-21-11 10:28:59 AM

Item ID: D2654-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 21/11/2011 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 02/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00	SAD	11-12-23		10			
Quality Control									
140	Identify as per dwg & Stock Location: <del>SGP</del>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00	SAD	11-12-23		(10)			
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

11/12/28 *[Signature]*

MF 11-12-22

W/O:		WORK ORDER CHANGES					
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# Picklist Print

November-21-11 10:29:04 AM

Page 1

Work Order ID: 76756

\*76756\*

Parent Item: D2654-1

\*D2654-1\*

Parent Item Name: Web

Start Date: 21/11/2011

Required Date: 02/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM  
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108 <i>090</i>		Manufactured	No			100	Each	261.0000	1	10			
*D2600-5-108*									**				
Extrusion 'I Beam' thin													

73867

RT 11-12-22

Location	Loc Qty	Loc Code
LG	261	
47814	20	
73909	241	

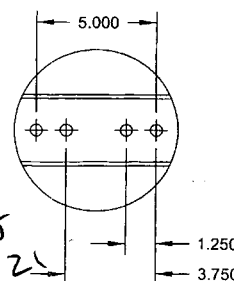
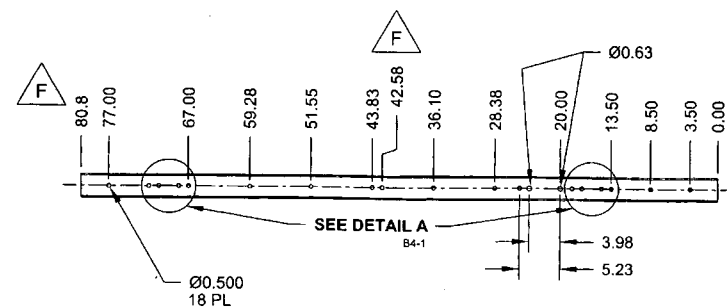
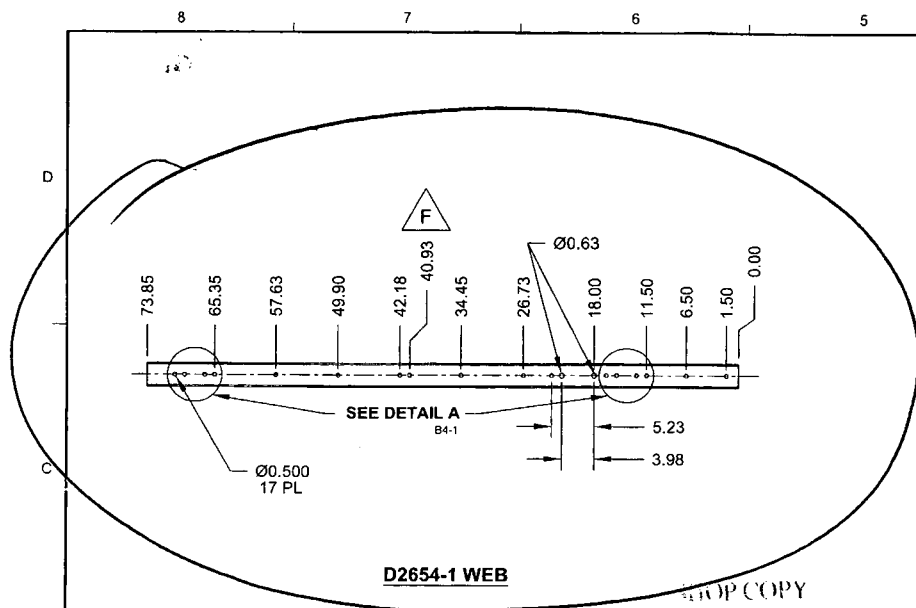
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DETAIL A

C2-1  
C3-1  
C5-1  
C6-1  
D3-2  
D6-2  
B3-2  
B6-2

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

76756 M.C.J.  
11/11/21

RELEASED  
2011-09-12

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DESCRIPTION	DATE
DRAWN	SC	<b>DART AEROSPACE USA, INC</b>	
CHECKED		PORT HADLOCK, WA	
MFG. APPR.		DRAWING NO. D2654	REV. F
APPROVED		TITLE	SHEET 1 OF 2
DE APPR.		WEB	SCALE
DATE	11.05.05		NTS

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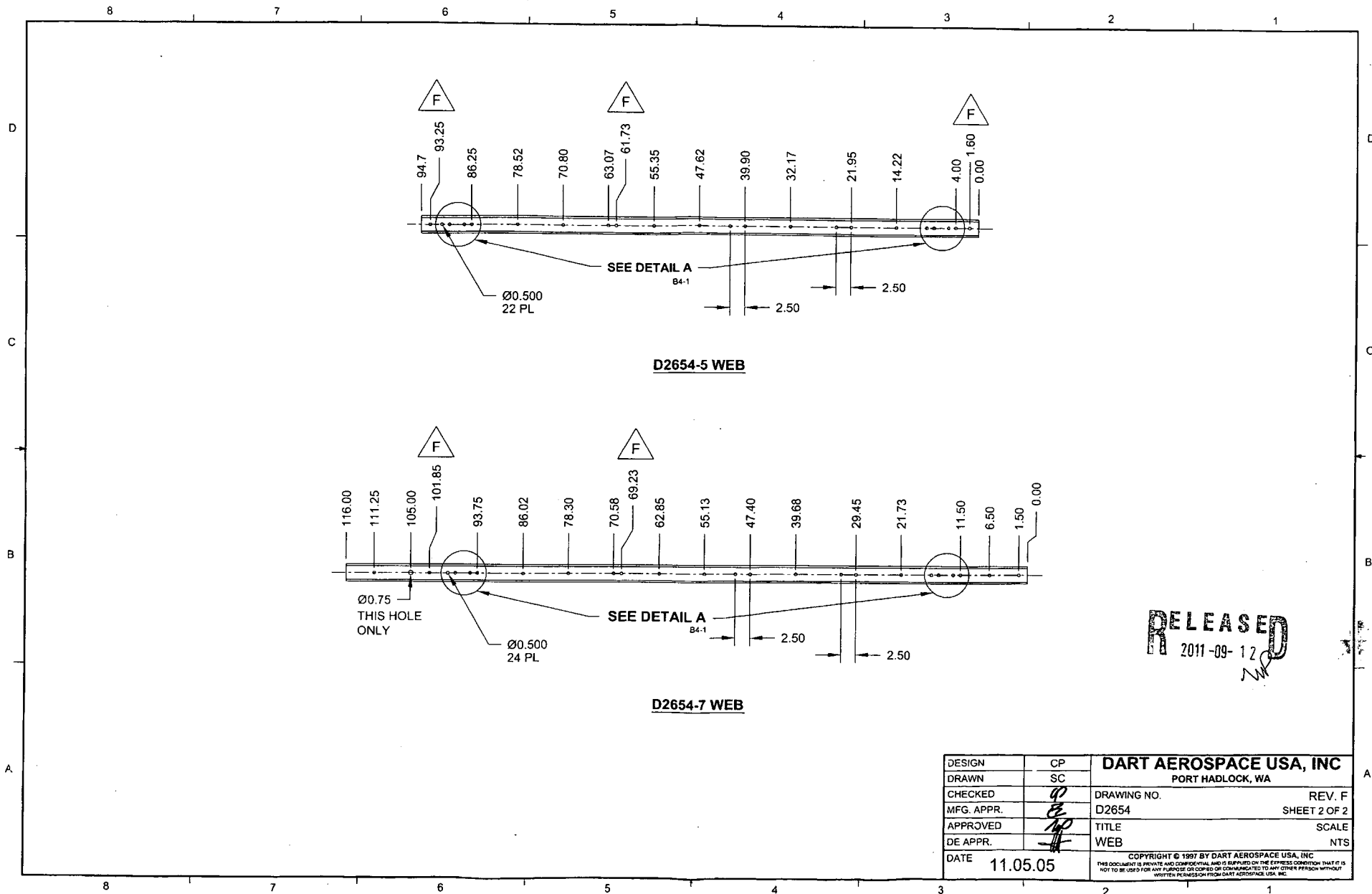
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